

# Work Order ID 98521

**\*98521\***

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March 12, 2013 1:50:50 PM

Item ID: D4381-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: X-tube Strap Bumper  
 Start Date: 3/12/13 Start Qty: 100.00 **\*100\*** Cust Item ID:  
 Required Date: 3/22/13 Req'd Qty: 100.00 **\*100\*** Customer:  
 Reference:

Approvals: Process Plan: CL Date: 13/03/12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence Work Center ID	Operation Description	Set Up Run Hours	Job ID	Lot #	Plan Code	Accept Qty	Reject Qty	Reject Number	Resp. Stamp
<b>Draw Nbr</b> D4381	<b>Revision Nbr</b> A								
100	PURCHASING	0.00							
<b>*100*</b> Purchasing Purchasing	<b>Memo</b> Issue P/O: <u>19315</u> Manufacture as per Dwg D4381 Possible Supplier: VIP Rubber Company, Inc Material release note required	0.00							<u>CL 13/03/12 100</u>
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*110*</b> Packaging Packaging	<b>Memo</b> Ensure Material Release Note is attached	0.00							<u>13/3/28 107</u>
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b> QC Quality Control	<b>Memo</b> NEED A 100% VISUAL INSPECTION FOR ALL RECEIVED PARTS. FOR CRACKS OR LARGE VOIDS	0.00							<u>100</u>

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

**Work Order ID 98521****\*98521\***

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Item ID: D4381-1

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: X-tube Strap Bumper

Start Date: 3/12/13 Start Qty: 100.00

**\*100\***

Cust Item ID:

Required Date: 3/22/13 Req'd Qty: 100.00

**\*100\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>									
Packaging	Memo <i>57v85</i>	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*4/3/13 100**13/4/13**PLB-04-3*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>				
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data <input type="checkbox"/>										
Equip/Tooling <input type="checkbox"/>										
Operator <input type="checkbox"/>										
Material <input type="checkbox"/>										
Setup <input type="checkbox"/>										
Other <input type="checkbox"/>										
Process <input type="checkbox"/>										
Supplier <input type="checkbox"/>										
Training <input type="checkbox"/>										
Unapproved <input type="checkbox"/>										

FAULT CATEGORY				
<b>Landing Gear</b>  <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b>  <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

# Picklist Print

March 12, 2013 1:50:50 PM

Page 1

Work Order ID: 98521

Parent Item: D4381-1

Parent Item Name: X-tube Strap Bumper

Start Date: 3/12/13

Required Date: 3/22/13

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A 11.05.10 new issue DD verf;JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4381-1P X-tube Strap Bumper		Purchased	No			110	Each	0.0000	1	100			

4/3/27 (107)

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

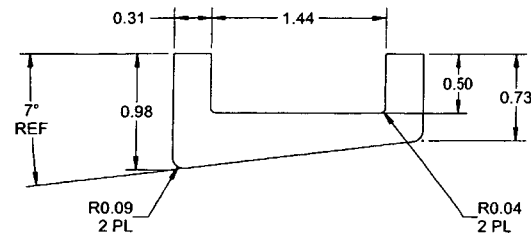
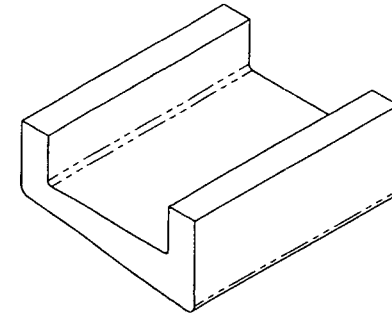
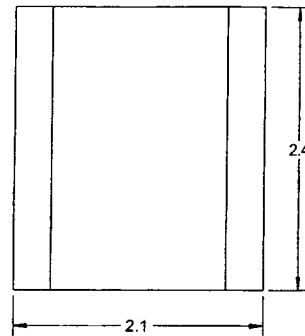
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
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		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



# **D4381-1 X-TUBE STRAP BUMPER**

02/3/03/12

W10.98521

## **NOTES:**

- 1) MATERIAL: POLYURETHANE, 80-85 DUROMETER, BLACK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.09 lbs APPROX

RELEASE  
2011-11-02

A	NEW ISSUE	AJS	11.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4381	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	X-TUBE STRAP BUMPER	NTS
DATE	11.04.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO19315**

Purchase Order Date 3/12/13

PO Print Date 3/12/13

Page Number 1 of 1

Order From :

VU-VIP001

VIP RUBBER COMPANY INC.  
540 SOUTH CYPRESS STREET  
LA HABRA, CA 90631  
US

Contact Name

Vendor Phone

562 905 3456

Vendor Fax

562 905 3460

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
3/13/13

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4381-1P	X-tube Strap Bumper	3/26/13 Yes	100.00 Each	FedEx PI collect	\$4.5500	\$455.00

Special Inst: AS PER DWG D4381 REV. A  
B98521

PO Total:

\$455.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 3/12/13

No substitution or deviation without  
consent.

Certificate of Conformity or Material  
Certification required - YES NO



All Materials  
Rubber  
Plastic  
TPE  
Molding  
Sheeting  
Extrusion  
Fabrication



# VIP Rubber and Plastic Company, Inc.

540 S. Cypress Street  
La Habra, CA 90631  
(562) 905-3456 (Phone)  
(562) 905-3460 (Fax)  
www.viprubber.com



Rubber / Plastic  
Metal Bonding  
Silicone  
PSA  
Sponge  
Cut To Length  
Co-Extrusion  
Hot Melt Tape  
And More...

## \*\*\*\*\*PACKING LIST\*\*\*\*\*

INVOICE DATE 3/27/2013

INVOICE NUMBER: 407337

SOLD TO: DART AEROSPACE LTD  
HAWKESBURY, ONTARIO  
CANADA K6A 1K7

SHIP TO: DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ONTARIO  
CANADA K6A 1K7

DATE	PURCHASE ORDER NUMBER	CUST #	F.O.B.	SALESPERSON
3/27/2013	PO19315	3626	ORIGIN	TOM LECLAIR
TERMS		SHIP VIA		
NET 30 DAYS		FEDEX P1		
SHIPPED	DESCRIPTION		PRICE	TOTAL
107.00 PCS	D4381-1P X-TUBE STRAP BUMPER EXCEPTION TO DWG NOTE 3 - QUOTED RMA COMMERCIAL TOLERANCE  84/CAST URETHANE			

ORDER COMPLETE.....THANK YOU

SHIPPING 1 CTN @ 11#

WE APPRECIATE YOUR BUSINESS  
BUY AMERICAN

**MERCHANDISE NOT RETURNABLE AFTER 30 DAYS**

The goods hereby sold are warranted free from defects in workmanship and materials for sixty (60) days from shipment to Buyer. No other express warranty is given no affirmation of Seller, by words or action, shall constitute a warranty.  
This warranty shall be limited to the repair or replacement of parts and the necessary labor and services required to repair the goods, or, at Seller's option, a refund of the purchase price, provided that the defect is reported to Seller and the goods are returned to the Seller within the warranty period. This warranty does not cover the results of ordinary wear and tear, or any part damaged by neglect, misused, accident, excessive deterioration due to corrosion from any cause, improper operation or maintenance, or any part damaged in the course of or as a result of installation, modification or adjustment performed by anyone other than the Seller or its authorized representative.

**IT IS EXPRESSLY AGREED THAT THIS LIMITED WARRANTY SHALL BE IN LIEU OF ALL OTHER WARRANTIES OF FITNESS AND IN LIEU OF THE WARRANTY OF MERCHANTABILITY. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE DESCRIPTION OF THE FACE HEREOF.**

It is expressly agreed that the replacement, repair or return of the goods and repayment of the purchase price, SHALL BE THE SOLE AND EXCLUSIVE REMEDIES OF BUYER with respect to any non-conforming goods and parts thereof and shall be in lieu of any other remedy available by applicable law. Seller in no event shall be liable for consequential damages arising out of or in connection with this sale of goods, including without limitation breach of contract or repudiation by Seller. Consequential damages shall include, without limitation, loss of use, income or profit, or losses sustained as a result of injury (including death) to any person or loss or damage to property.  
The foregoing terms cannot be waived or modified except by a writing signed by Seller.

**A LATE CHARGE OF 1% PER MONTH (18% PER ANNUM) WILL BE MADE ON PAST DUE BALANCES.**

All Materials  
Rubber  
Plastic  
TPE  
Molding  
Sheeting  
Extrusion  
Fabrication



Rubber and Plastic Products  
540 S. Cypress Street  
La Habra, CA 90631  
(562)905-3456 PHONE • (562) 905-3460 FAX  
[www.viprubber.com](http://www.viprubber.com)

Metal Bonding  
Silicone  
PSA  
Sponge  
Cut to Length  
Co-Extrusions  
Hot Metal Tape  
And More...

## **CERTIFICATION OF CONFORMANCE**

THIS IS TO CERTIFY THAT THE MATERIAL FURNISHED ON THIS PURCHASE ORDER WAS MADE IN  
STRICT ACCORDANCE WITH THE NOTED SPECIFICATION

**Sold to:**  
DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY, ONTARIO  
CANADA, \*\*\*\* K6A 1K7

**Ship to:**  
DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ONTARIO  
CANADA, K6A 1K7

Lot #: GA2L19U310

Shipper ID: 407337

P/N and DWG#: D4381-1P, DWG#: D4381 REV A

Quantity	
Ordered	Shipped
100 PCS	107 PCS

Customer PO# PO19315

Cure Date: 1-Q-13

Date Shipped: 3/27/2013

Description: X-TUBE STRAP BUMPER

EXCEPTION TO DWG NOTE 3 - QUOTED RMA COMMERCIAL TOLERANCE

### **Specification**

84/CAST URETHANE

  
Quality Control Inspector

PREPARED BY: Claudia Hargett

VIP Rubber Company, Inc. • 540 S. Cypress Street • La Habra • California • 90631 • 800-722-4VIP • 562-905-3456

